

What is claimed is:

1. A method of continuously seaming wide panels of cured EPDM membrane to form a composite roofing membrane of predetermined width and indefinite length comprising:
 - 5 providing at least two rolls of wide panels of cured EPDM membrane having longitudinal marginal edges;
 - feeding the wide panels of cured EPDM membrane from the at least two rolls in a first direction;
 - 10 simultaneously positioning longitudinal marginal edges of the cured wide panels of EPDM membrane in an overlapping relationship as the cured wide panels of EPDM membrane are fed in the first direction; and
 - seaming the overlapping cured edges of the EPDM membranes to form a composite roofing membrane.
- 15 2. The method of Claim 1 wherein the overlapping marginal edges of the wide panels of cured EPDM membrane include a preapplied adhesive there between.
3. The method of Claim 1 further comprising the step of applying an adhesive between the overlapping marginal edges of the wide panels of cured EPDM membrane.
- 20 4. The method of Claim 3 wherein the adhesive is selected from TPO or TPE.
5. The method of Claim 2 wherein the adhesive is selected from TPO or TPE.
- 25 6. The method of Claim 2 wherein the overlapping cured EPDM membranes are seamed by heating the area of overlap to weld the overlapping cured EPDM membranes and then compressing the area of overlap to form a seam.
- 30 7. The method of Claim 1 wherein the overlapping cured EPDM membranes

are seamed by applying an adhesive between the overlapping cured EPDM membranes and then compressing the area of overlap to form a seam.

8. The method of Claim 1 further comprising the step of cutting the composite roofing membrane to a desired length.

9. An apparatus for continuously seaming wide panels of cured EPDM membrane to form a composite roofing membrane of predetermined width and indefinite length comprising:

10 at least two supply stations for supplying and simultaneously positioning indefinite length stock of wide panel cured EPDM membrane in an overlapping relationship;

15 a seaming station for continuously seaming the overlapping cured EPDM membranes to form a composite roofing membrane of predetermined width and indefinite length; and

a storage station for continuously reeling the composite roofing membrane.

20 10. The apparatus of Claim 9 wherein the supply station includes a supply roll containing cured EPDM membrane of indefinite length and selected width and a tensioning device to maintain a constant tension on the cured EPDM membrane as the membrane is fed from the supply roll to the seaming station.

25 11. The apparatus of Claim 10 wherein the tensioning device includes a support roll that supports the cured EPDM membrane as the membrane is fed from the supply roll and a tensioning roll pivotally connected to maintain a downward pressure on the cured EPDM membrane between the supply roll and the support roll.

30 12. The apparatus of Claim 11 wherein the supply stations are arranged in an overlapping manner to facilitate the overlapping of cured EPDM membrane.

13. The apparatus of Claim 12 wherein the supply stations are arranged in an alternating overlapping arrangement.

5 14. The apparatus of Claim 12 wherein the supply stations are arranged in a step-wise arrangement.

10 15. The apparatus of Claim 9 wherein the seaming station includes a frame member supporting a press assembly and a device for seaming the overlapping cured EPDM membranes, the press assembly including pinch rollers to compress the overlapping edges thereby securing the membranes together to form a seam.

15 16. The apparatus of Claim 15 wherein the seaming station includes a plurality of hot air guns to heat the area of overlap to weld the overlapping cured EPDM membranes together and form a seam.

17. The apparatus of Claim 15 wherein the seaming station includes an adhesive applicator for applying adhesive between the overlapping wide panels of cured EPDM membrane.

20 18. The apparatus of Claim 9 wherein the storage station includes a rotatable take-up roll onto which the composite roofing membrane is rolled for storage purposes.